

Work Order ID 128663

128663

Page 1

January-21-15 12:33:13 PM

Item ID: D355-600-243

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/09/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D355-600

Rev C

0.00

100

Document Control

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D355-600-243 CHG002

ML5

1502-10

Work Order ID 128663

128663

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Item ID: D355-600-243 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacepod™ Fwd Opening LH AS 355
 Start Date: 1/16/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/09/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--

110

Small Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Small Fab	PULL FROM STK;								
-----------	----------------	--	--	--	--	--	--	--	--

1 X D355-600-143 B98652
 MODIFY PER IIN 3.4
 TO MAKE D355-600-243
 SEE ATTACHED

used Epocast m 131354

FG778150-550 3 yards B127701

1-Drill holes in D3188-1 using drill jig DT8970 2-Open holes in D3188-1
 body floor to Ø0.297" as per dwg D3188 3-Deburr4-Install inserts in D3188-
 1 as per Dwg D3188.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: SW Date: 15/03/20QA Closed: SW Date: 15/03/20

Work Order: <u>128663</u> Part No. <u>D355-600-243</u> NCR No. <u>15-4685</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☒</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☒	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☒	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	15.01.26	110	1	IIN-D355-600 calls for screws + rivets to be installed after removing unnecessary hardware for food opening pod wiper section 3.4.2	A.P. 15.01.26	For rivet + hardware holes in pod that are no longer needed. chamfer both sides of hole + Fill with Hysol 934 + 10% milled fibre	15-01-27	DAS 38 9-89 15-02-09	DAS 9 9-89 15-02-09
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped.	☐ Burrs	☒ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Misabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: JA Date: 15/04/08QA Closed: JA Date: 15/04/08

Work Order: <u>128663</u> Part No. <u>D355-600-243</u> NCR No. <u>15-4784</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☒</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☒	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☒	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	15.01.26	110	x1	when using dimensions from 11N-0330-600 Figure 13(a) the min 1.5" dim becomes 0.7" if the 5.1" and 7.8" dimensions are used 2C Design	A.P. 15.01.26	use 5.1" and 7.8" dim's for upper "Footrests" of form in door - disregard the "min 1.5" dimension MAINTAIN 1.5" MIN DIM, DISREGARD 5.1 AND 7.8 DIMS	<u>JA</u> 15-01-26	DAS 38 9-89 15-02-09	DAS 9 9-89 150609
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☒ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: DAI Date: 15/04/08QA Closed: DAI Date: 15/04/06

Work Order: <u>128663</u> Part No. <u>D355-600-243</u> NCR No. <u>15-4785</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☒</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☒</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☒	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☒	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☒															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☒	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	15-01-26	110	①	QSR needs update for product name + mix ratio	A.P. 15.01.26	use Epocast 50-A1 and 9816 hardener as per instructions on can to laminate repairs	<u>DAI</u> 15-01-27	DAS 38 9-89 15-02-09	DAS 9 9-89 15-02-09
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY ☒

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☒ Other

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AK Date: 16/04/08QA Closed: DDM Date: 15/04/06

Work Order: <u>D28663</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D35600-243</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4786</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☒	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	15-01-28	110	x8	original screws for D2857-1/D2857-2 hinge brackets too short due to rework + added thickness to door	A.P. 15.01.28	use AN526C 832R12 and replace nut MS21042LO6 • ENSURE 1.5-4 THREADS PAST END OF NUT AN526C 832R10 B 123631 x4 AN526C 832R12 B 117543 x4 MS21042LO6 B 170325 x6	15-01-28	DAS 38 9-89 15-02-09	DAS 9 9-89 15-02-09
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☒									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

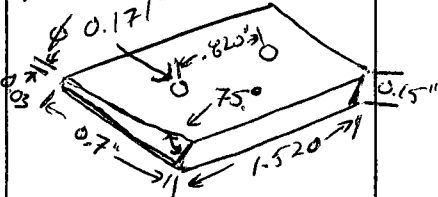
pick one P/S. Entric to O/S Tube Torque waves in Extrusion Turning Sequence Wave/Twist in Tube	☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☒ Grain ☒ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions	☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: SWA Date: 15/04/08QA Closed: RPM Date: 15/04/08

Work Order: <u>128663</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS ✓			
Part No. <u>D355600-243</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4787</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☒	Supplier ☐	

Root Cause ✓	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	15-02-02	150	x1	in location of D2179 top hinge location the nuts M521042LOS and washers M511490N8165 do not sit properly due to the curve in the foam	A.P. 15.02.02	install an aluminum shim  Abalone & Powder coat white	 15-02-02	38 9-89 15-02-09	DAS 9 9-89 15-02-09

FAULT CATEGORY ✓

Landing Gear	General	Grain	Other
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized
☐ Centre Not Concentric to O/S	☐ BOM/Route	☒ Hardware	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved
☐ Heat Treat	☐ Countersink	☐ Misabeled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	☐ Pressure/Forced
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	☐ Temperature/Cure
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	☐ Weld
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	☐ Wrong Stock Pulled
			☐ Other

Work Order ID 128663***128663***

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Item ID: D355-600-243

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/09/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
120									
QC	Memo	0.00							15-02-09
Quality Control									
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00							15-02-02
Small Fab	Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600 ***Hardware on previous steps is for door ass'y****								
	1-drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled glass fibres 10% to weight								
	A/R Hysol batch: 131276								

Work Order ID 128663

128663

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January-21-15 12:33:13 PM

Item ID: D355-600-243 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacepod™ Fwd Opening LH AS 355
 Start Date: 1/16/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/09/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC4- 100% Inspect kits for completeness	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

FEB 10 2015

200	Packaging	0.00							
2000									
Packaging	Memo	0.00							
Packaging									

REMOVE THE FOLLOWING AND RETURN TO STOCK:
 1 X D350-600-349 B
 1 X D3548-1 B
 1 X D3549-1 B
 1 X K10018 B
 NOT in kit - 15-2-10
 (98652)
 DAS
06
9-89

REPACKAGE USING NEW B/N
 Identify and pack for shipping as per PPP D355-600-
 243 Location: _____

PPP Rev: _____

DAS
06
9-89

FEB 11 2015

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Item ID: D355-600-243

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/09/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MW 15-02-11

15-02-11

Picklist Print

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Page 1

Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.11.27 new issue EC
IPP Rev:B 08-12-09 chg as per DSI9401 DD verified by:EC IPP REV:C
14.07.16 as per DSI9700 rev.a DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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A3235-020-935

Purchased

No

130

Each

179.0000

8

8

A3235-020-935

Washer, Countersunk

81 15-02-11

Location

Loc Qty

Loc Code

ST548

179

106150

179

ALS4-1032-130

AELS4-1032-130

Purchased

No

110

Each

3,327.000

28

28

ALS4-1032-130

Rivnut

81 15-02-11

Location

Loc Qty

Loc Code

FP001

2256

M128649

2256

st549

1071

M128649

1071

AN3-6A

Purchased

No

Each

272.0000

7

AN3-6A

Bolt

DAS
27
8-89

DAS
86
8-89

Location

Loc Qty

Loc Code

ST338a

100

M131305

100

ST349

172

M128739

72

M130466

100

FEB 10 2015

u

Picklist Print

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Work Order ID: 128663

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Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

AN526C832R10

Purchased

No

150

Each

124.0000

8

8

AN526C832R10

Screw

15-02-11

Location

Loc Qty

Loc Code

ST327

124

123831

24

m127363

100

AN526C832R10

Purchased

No

190

Each

124.0000

2

2

AN526C832R10

Screw

15-01-28

Location

Loc Qty

Loc Code

ST327

124

123831

24

m127363

100

AN526C832R14

Purchased

No

150

Each

131.0000

2

2

AN526C832R14

Screw

15-01-28

Location

Loc Qty

Loc Code

ST327

131

124215

131

D2179

Manufactured

No

140

Each

30.0000

2

2

D2179

Hinge Bracket Plate

15-02-11

Location

Loc Qty

Loc Code

ST004

30

106233

24

35432

6

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

D2228

Manufactured No

150

Each

50.0000

4

D2228

Backing Plate

**

x2
81

15 - 01 - 28

Location

Loc Qty

Loc Code

ST005

21

73380

1

95704

20

ST012a

29

105984

29

x2
x1

D2237

Manufactured No

140

Each

48.0000

2

D2237

Striker Plate

**

2

15 - 01 - 28

Location

Loc Qty

Loc Code

ST005

48

121746

48

x2

D2464

Manufactured No

150

f

853.0000

10.8

12

D2464

Seal(\$per foot)

**

81

15 - 02 - 03

Location

Loc Qty

Loc Code

CA2

1

110770

1

ST409

10

110770

10

ST638

842

121946

815

83543

27

x12

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

D2585

Manufactured No

150

Each

58.0000

2

2

D2585

Latch Clamp

15-01-28

Location

Loc Qty

Loc Code

ST008

58

123519

14

127709

44

12

D2586

Manufactured No

150

Each

26.0000

2

2

D2586

Door Latch

15-02-11

Location

Loc Qty

Loc Code

FG

16

100607

1

114985

5

119746

4

83893

5

95760

1

ST482

10

127402

10

D2621

Manufactured No

150

Each

22.0000

2

2

D2621

Latch Plate

15-02-11

Location

Loc Qty

Loc Code

FG

2

88616

2

ST008A

20

123542

20

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

D2857-1 Manufactured No

150 Each 45.0000 1 1

D2857-1

Hinge Bracket

15-02-11

N/A

Location	Loc Qty	Loc Code
FG	5	
82261	4	
91914	1	
ST012	16	
120387	16	
ST012a	24	
121829	24	

D2857-2 Manufactured No

150 Each 31.0000 1 1

D2857-2

Hinge Bracket

15-02-11

N/A

Location	Loc Qty	Loc Code
FG	3	
78904	3	
ST012	4	
121410	4	
ST012a	24	
114154	24	

D2985 Manufactured No

190 Each 13.0000 1 1

D2985

Label

DAS
27
9-89

DAS
26
9-89

Location	Loc Qty	Loc Code
ST014	13	
104987	9	
106718	4	

D2986 Manufactured No

140 sf 0.0000 5.62 6

D2986

Black Neoprene 2" X 3"

FEB 10 2015

u

N/A

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

D3015-3 Manufactured No

110 Each 67.0000 1 1

D3015-3

Locknut

15-01-28

Location	Loc Qty	Loc Code
FG	18	
95758	8	
96151	10	
ST015	49	
117832	49	

D3015-3 Manufactured No

140 Each 67.0000 1 1

D3015-3

Locknut

B66114 sel

Location	Loc Qty	Loc Code
FG	18	
95758	8	
96151	10	
ST015	49	
117832	49	

D3188-3M Manufactured No

110 Each 0.0000 1 1

D3188-3M

Spacepod Body LH (355)

D350-600-449

Manufactured No

190 Each 1.0000 1 1

D350-600-449

Switch Relocation

DAS
27
9-89

Location	Loc Qty	Loc Code
FG125	1	
125167	1	

DAS
86
9-89

B127818

FEB 10 2015

u

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

D3538-1 Manufactured No

140 Each

12.0000 2 2

D3538-1

Hinge Bracket

**** 128374 15-01-29**

Location

Loc Qty

Loc Code

FG

12

105999

2

115602

3

84630

1

98281

6

D3547-1 Manufactured No

190 Each

26.0000 1 1

D3547-1

Bracket

DAS 27

FEB 10 2015

Location

Loc Qty

Loc Code

ST049

26

106211

26

3579SI

D3550-1 Manufactured No

190 Each

5.0000 1 1

D3550-1

Strut

DAS 27

FEB 10 2015

Location

Loc Qty

Loc Code

ST358

5

101529

1

112152

1

83114

3

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

D3552-7

Manufactured No

190 Each

13.0000

1

1

D3552-7

Door Prop

DAS
27

9-89

FEB 10 2015

DAS
65
9-89

Location

Loc Qty

Loc Code

FG

2

85044

2

ST363

11

106032

3

115663

1

118882

5

83115

2

D3554-7

Manufactured No

140 Each

27.0000

1

1

D3554-7

Ball Stud

15-01-28

Location

Loc Qty

Loc Code

FG

5

87039

5

ST049

22

87571

22

D3554-7

Manufactured No

190 Each

27.0000

1

1

D3554-7

Ball Stud

DAS
27

9-89

FEB 10 2015

DAS
65
9-89

Location

Loc Qty

Loc Code

FG

5

87039

5

ST049

22

87571

22

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

D355-600-143

Manufactured No

Each

1.0000

1

D355-600-143

Spacepod Upward Opening LH AS 355

**

1

Location

Loc Qty

Loc Code

Mezz

1

98652

1

D3557-1

Manufactured No

150

Each

16.0000

1

1

D3557-1

Bracket

**

15-01-28

Location

Loc Qty

Loc Code

ST049

16

125281

2

126308

10

73384

4

D3567-1

Manufactured No

140

Each

4.0000

1

1

D3567-1

Decal

**

15-01-28

Location

Loc Qty

Loc Code

ST049

4

48254

4

D3567-1

Manufactured No

150

Each

4.0000

1

1

D3567-1

Decal

**

1

DAS
27
8-89

FEB 10 2015

Location

Loc Qty

Loc Code

ST049

4

48254

4

DAS
66
8-89

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128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

D3722-1 Manufactured No

140 Each 40.0000 2 2

D3722-1

Spacer Wedge



Location

Loc Qty

Loc Code

Mezz

40

55342

40

Each

18.0000

2

FEB 10 2015

D5127-1 Manufactured No

Each 18.0000 2

D5127-1

Shim, Large

Location

Loc Qty

Loc Code

ST149

18

125150

8

127406

10

Each

14.0000

2

D5127-3 Manufactured No

Each 14.0000 2

D5127-3

Shim, Small

Location

Loc Qty

Loc Code

ST149

14

125370

4

127632

10

Each

0.0000

1

K10021 Manufactured No

190 Each 0.0000 1 1

K10021

Spacepod Hardware (-241)



DAS
06
9-89

FEB 10 2015

B127620

FEB 10 2015

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Purchased

No

140

Each

2,681.000

4 / 4

MS20426AD4-5

**

85 15-01-28

RIVET

Location

Loc Qty

Loc Code

GA

110

m125807

110

ST312

2571

m125807

186

m130922

2385

MS21042L08

Purchased

No

150

Each

1,169.000

41 x 10

MS21042L08

**

85 15-01-28

Nut

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST304

1068

123900

16

m128401

210

m130325

342

m131317

500

MS21042L3

Purchased

No

150

Each

2,893.000

2 / 2

MS21042L3

**

85 15-01-28

Nut

Location

Loc Qty

Loc Code

FP001

420

M130922

420

ST305

2470

M130799

11

M131264

1459

M131317

1000

ST307

3

123900

3

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

150

Each

417.0000

2

2

MS27039-08-11

SCREW

15 - 01 - 28

Location

Loc Qty

Loc Code

ST282

417

m130358

417

x 2

MS27039-1-15

Purchased

No

150

Each

185.0000

2

2

MS27039-1-15

Screw

15 - 01 - 28

Location

Loc Qty

Loc Code

GA

99

m127916

99

x 2

ST285

86

m127916

86

MS27039C0-827

Purchased

No

140

Each

16.0000

4

4

MS27039C0-827

SCREW

FEB 10 2015

Location

Loc Qty

Loc Code

Mezz

16

106298

16

4

DAS
06
9-89

u

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

150

Each

1,619.000

2

NAS1149D0363.J

Washer

2

2

15-01-28

Location

Loc Qty

Loc Code

CA

673

m130799

673

FP001

147

m126319

147

GA

732

m128429

732

ST269

67

122378

15

m126319

52

NAS1149D0563J

Purchased

No

140

Each

1,920.000

1

1

NAS1149D0563.J

Washer

1

15-01-28

Location

Loc Qty

Loc Code

GA

130

m125807

130

ST260a

400

m130799

400

ST269

390

16527

4

m128257

386

ST271

1000

m131026

1000

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

190

Each

1,920.000

2

2

NAS1149D0563.J

sf

Washer

Location

Loc Qty

Loc Code

GA

130

m125807

130

ST260a

400

m130799

400

ST269

390

16527

4

m128257

386

ST271

1000

m131026

1000

NAS1149DN816J

Purchased

No

140

Each

445.0000

4

NAS1149DN816.J

4 15-01-28

WASHER

N/A

Location

Loc Qty

Loc Code

ST270

445

m128057

445

NAS1149DN832J

Purchased

No

140

Each

1,042.000

4

NAS1149DN832.J

4 12 15-01-28

Washer

Location

Loc Qty

Loc Code

MF4

185

M129541

185

ST270

857

124555

59

M128429

114

M129499

84

M131317

600

7 12

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Work Order ID: 128663

128663

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS 355

Start Date: 1/16/15

Required Date: 2/09/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

150

Each

1,042.000

4

4

NAS1149DN832.J

Washer

15 - 02 - 11

Location

Loc Qty

Loc Code

MF4

185

M129541

185

ST270

857

124555

59

M128429

114

M129499

84

M131317

600

NAS1515H3

Purchased

No

150

Each

121.0000

2

2

NAS1515H3

Washer

15 - 01 - 28

Location

Loc Qty

Loc Code

FG

10

123301

10

GA

72

m129521

72

ST266

39

m128635

39

D3187-1 x 1 B.59334

DAS
06
8-89

AN526 C 832 R 24

118870 x 2

15 - 01 - 28

AN 526 C 832 R 28

A.P.

15.02.02

x 1

m 131467

15 - 02 - 09

AN 526 C 832 R 32

A.P.
15.02.05

x 1

m 131511

15 - 02 - 09

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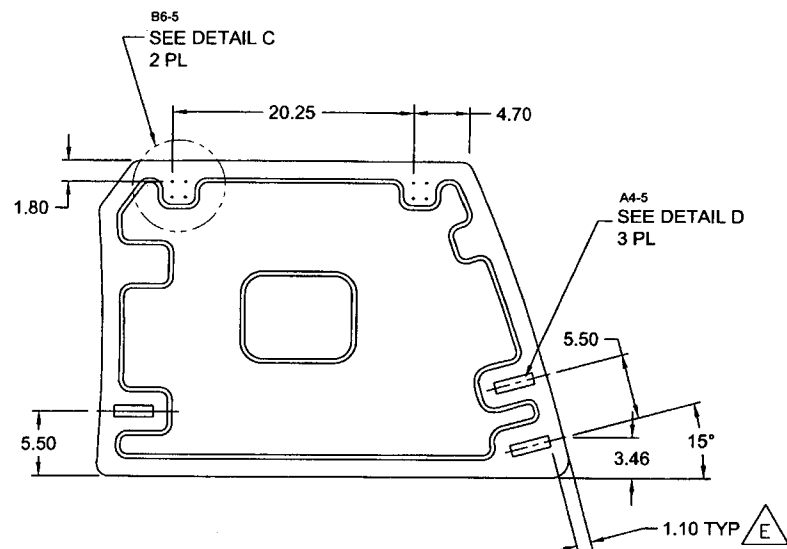
8 7 6 5 4 3 2 1

D

C

B

A

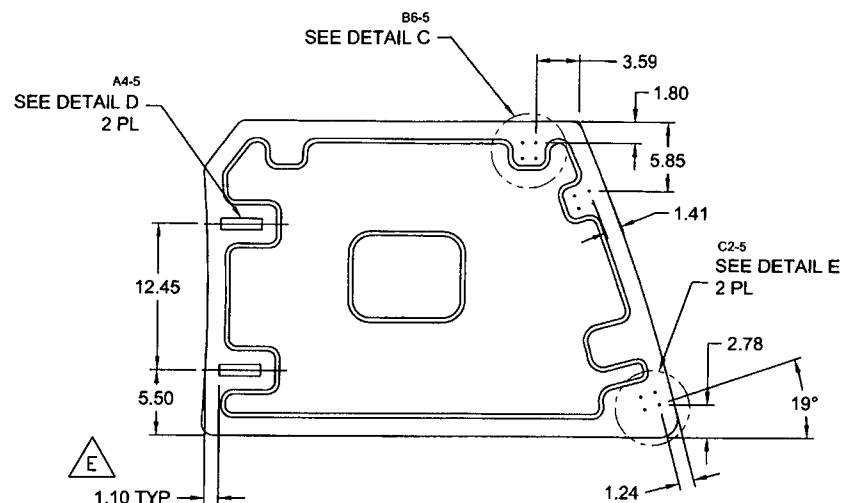


D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

128663



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.			SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

3.4 FORWARD OPENING SPACEPOD™ UPGRADE KIT INSTALLATION (D350-600-249)

- 3.4.1 Remove the existing D3186-1/-2 *Spacepod™* door by disconnecting the hinges.
- 3.4.2 Remove the following components from the door and pod as shown in Figure 11:
- Remove the D2977/D2978 hinge brackets and D2179 hinge bracket plates from the pod. Reinstall the hardware to fill the holes in the pod. Retain the hinge bracket plates for reinstallation. Discard the hinge brackets.
 - Remove the D2857-1/-2 hinge brackets and the D2228 backing plates and retain for reinstallation. Reinstall the mounting hardware in the aft set of holes only. Discard the remaining mounting hardware.
 - Remove the two forward D2586 latches, D2621 latch plates and D2588 mounting channels along with the D2982-041 prop arm assembly, the D2012-107 clevis assembly and D2429-041 spring clip assembly. Retain one D2586 latch, one D2621 latch plate and one D2588 mounting channel for reinstallation. Discard the other parts and hardware.
 - Remove the SL69-BS ball stud and discard.
 - Optional – remove the D2219 door support bracket by drilling out the rivets. Fill in the pod rivet holes in pod using new rivets.

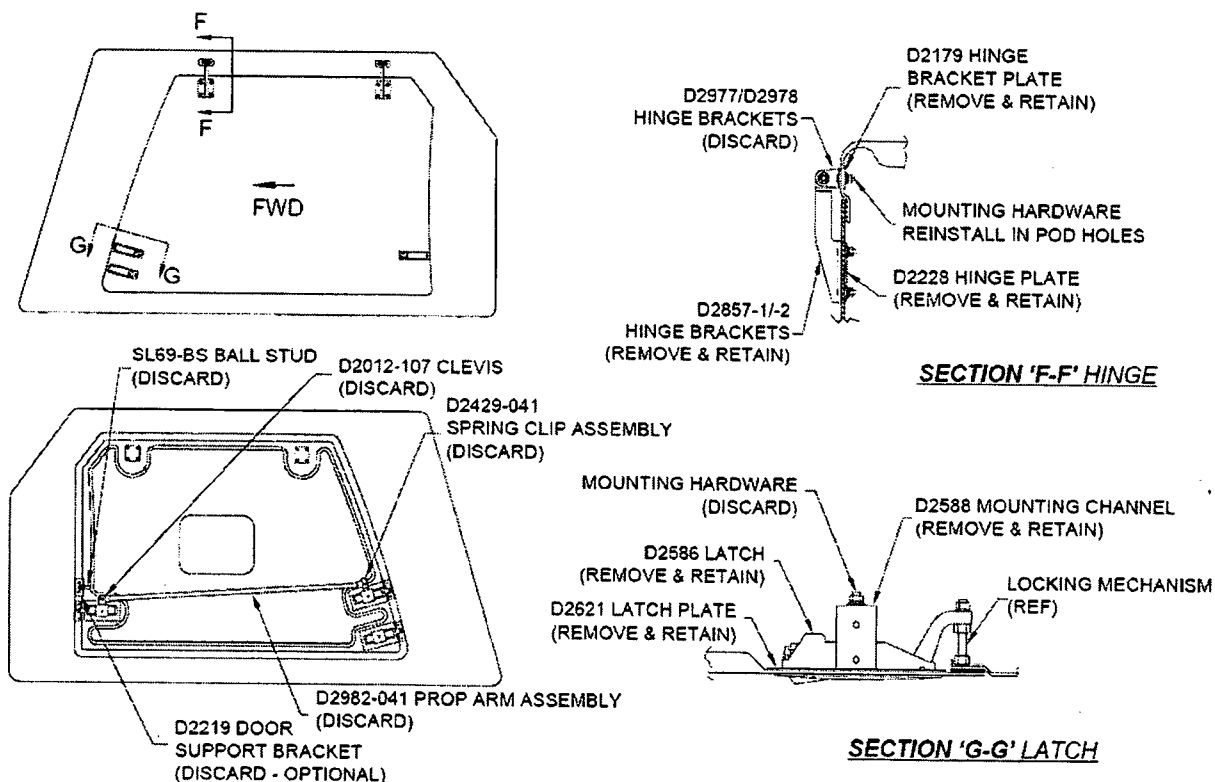


FIGURE 11 – COMPONENT REMOVAL FROM EXISTING SPACEPOD™ KIT
(D350-600-041/-141 KIT SHOWN; -042/-142 OPPOSITE, -043/-143 SIMILAR)

- 3.4.3 Fill each of the two forward latch holes as shown in Figure 12. (Note that it is optional to fill in only the lower latch hole and to leave the latch in the upper latch hole. If this option is chosen, remove the locking mechanism from the latch. Refer to Figure 11).
- Prepare a pre-cured fiberglass plug to fit the hole using alternating 45° layers of cloth. Ensure that the plug has the same thickness and size of the opening.
 - Prepare two plies of 9 oz 7781 glass cloth that will overlap the hole by 0.5". Prepare two plies of 9 oz 7781 glass cloth that will overlap the hole by 1" and that are oriented 45° from the first set of plies. Prepare two plies of 9 oz 7781 glass cloth that will overlap the hole by 1.5" and that are oriented in the same direction as the first set of plies.
 - Prepare the door surface by sanding a minimum of 1.5" from each edge of the hole on both sides of the door to a minimum of 80-grit. Remove the D2464-1250 neoprene seal around the area as needed. Remove dust and grease using a mild solvent. Wipe the solvent before drying. Ensure that all paint, primer and grease are removed.
 - Bond the plug in the opening with Hysol EA9309NA adhesive paste or equivalent.
 - Layer 3 plies of glass cloth on each side of the hole from smallest to largest with Epocast 50-A/9816 or Hysol EA9309NA resin.
 - Apply pressure to both sides of the hole and allow the resin to cure.
 - Smooth the applied area and prime and paint.

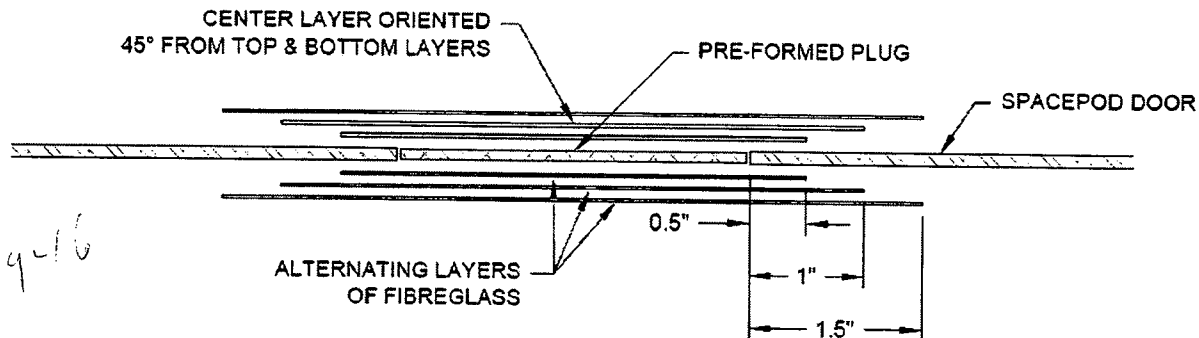


FIGURE 12 – LATCH HOLE REPAIR IN SPACEPOD™ DOOR

- 3.4.4 Prepare the new latch and hinge bracket mounting locations as shown in Figures 13(a) and 13(b):
- Cut away the inner fiberglass layer and the thick foam layer on the Spacepod™ door as shown. Leave a 45° tapered edge along each area.
 - Prepare two plies of 9 oz 7781 glass cloth that will overlap each exposed area by 1" and by 1.5", respectively. Ensure that the two plies are oriented 45° to each other.
 - Prepare the door surface by sanding a minimum of 1.5" from each edge surrounding the exposed areas on the inner surface of the door to a minimum of 80-grit. Remove the D2464-1250 neoprene seal around the area as needed. Remove dust and grease using acetone or equivalent solvent. Wipe the solvent before drying. Ensure that all paint, primer and grease are removed.
 - Layer the two plies of glass cloth on each exposed area from smallest to largest with Hysol EA9309NA or Epocast 50-A/9816 resin.
 - Apply pressure to the area and allow the resin to cure.
 - Smooth the applied area and prime and paint.

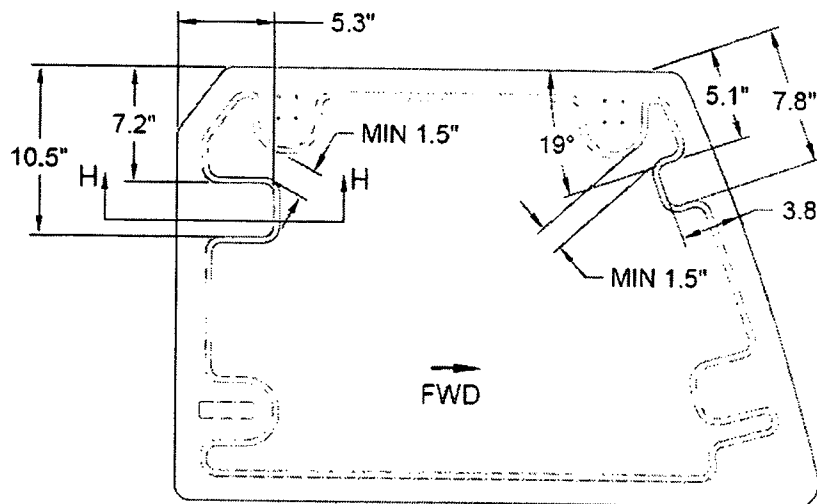


FIGURE 13(a) – D3186-1 SPACEPOD™ DOOR COMPOSITE MODIFICATION
(APPLICABLE FOR -041/-043/-141/-143 KITS)

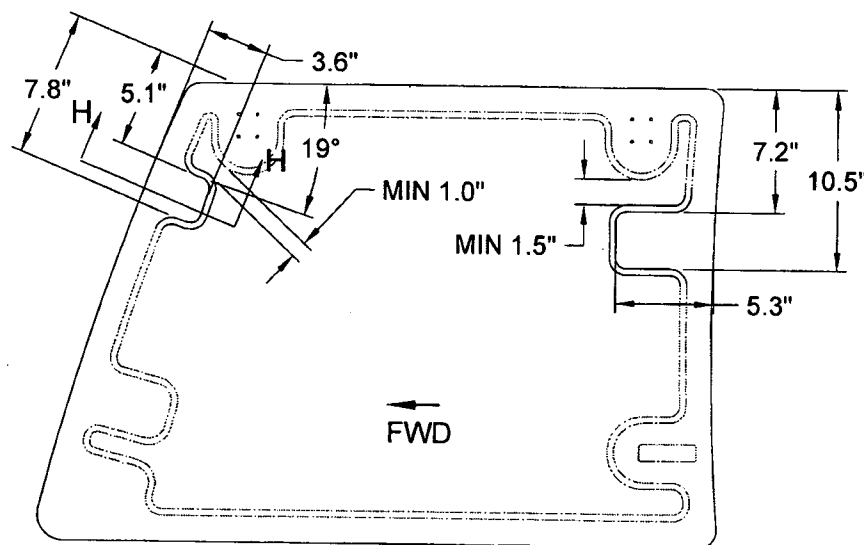
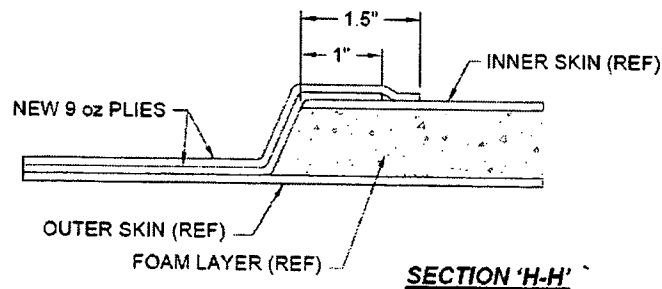


FIGURE 13(b) – D3186-2 SPACEPOD™ DOOR COMPOSITE MODIFICATION
(APPLICABLE FOR -042/-142 KITS)



SECTION 'H-H'

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Revision: **E**
Date: 09.07.31

- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

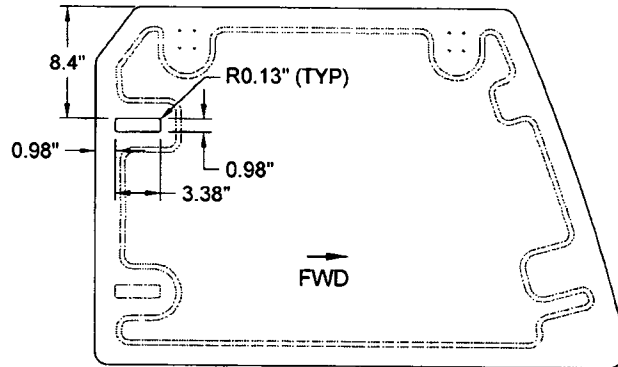


FIGURE 14(a) – D3186-1 SPACEPOD™ DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

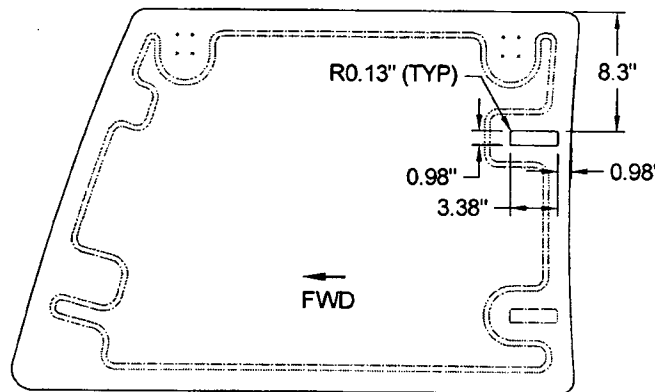


FIGURE 14(b) – D3186-2 SPACEPOD™ DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

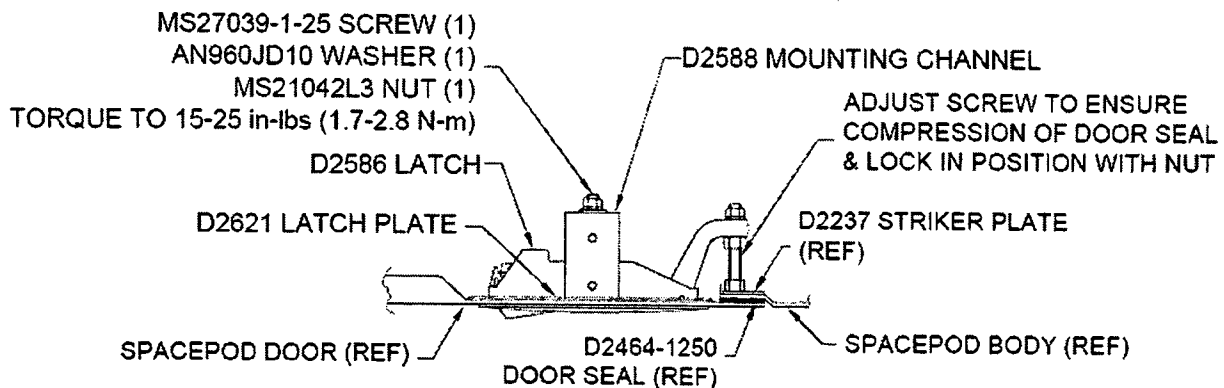


FIGURE 14(c) – LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

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- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the $\varnothing 0.172$ " mounting holes on each bracket to the *Spacepod™* door. Install the hinge brackets as shown in Section J-J.

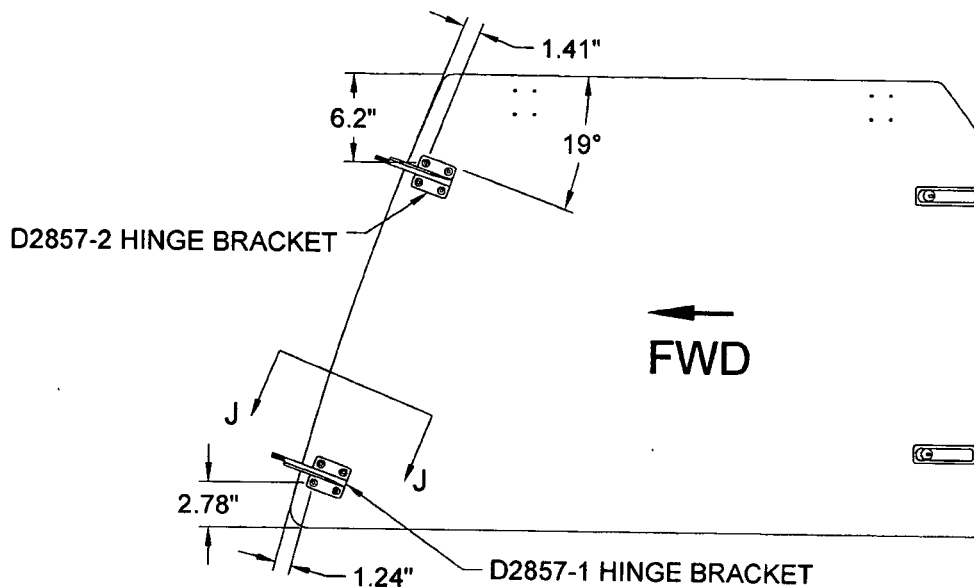


FIGURE 15(a) – HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD™ DOOR

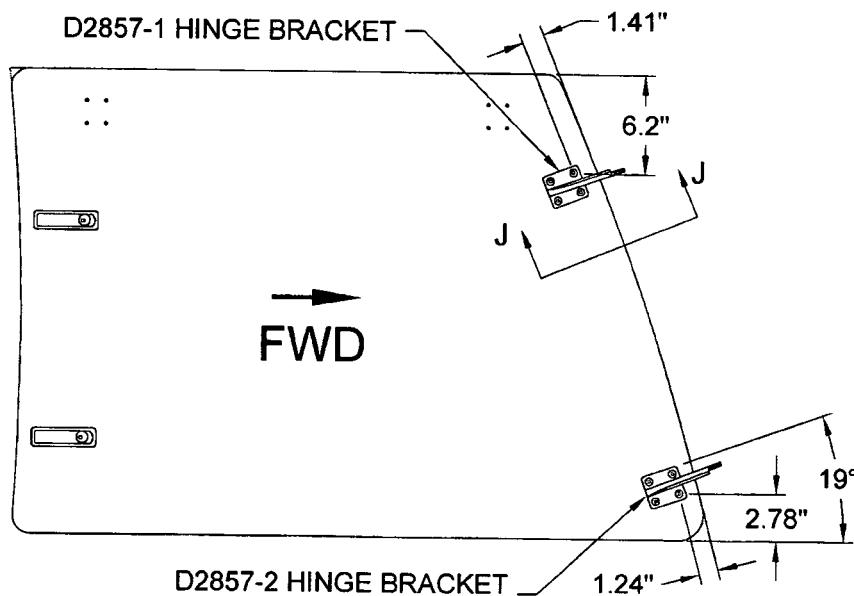
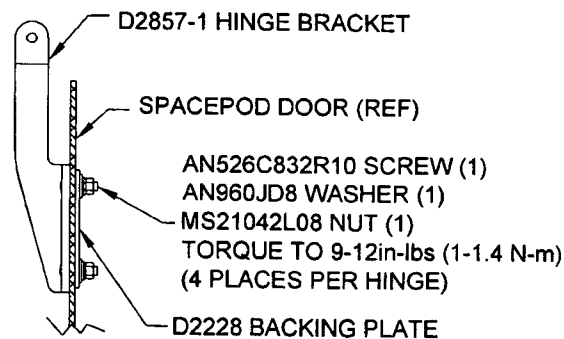


FIGURE 15(b) – HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD™ DOOR



SECTION 'J-J' HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.

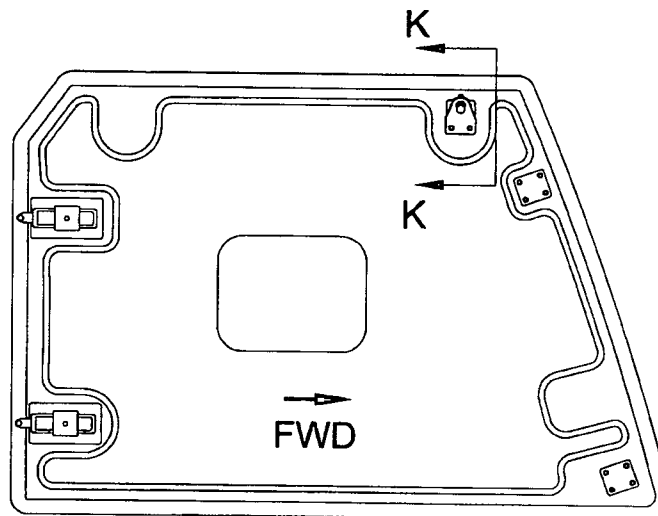
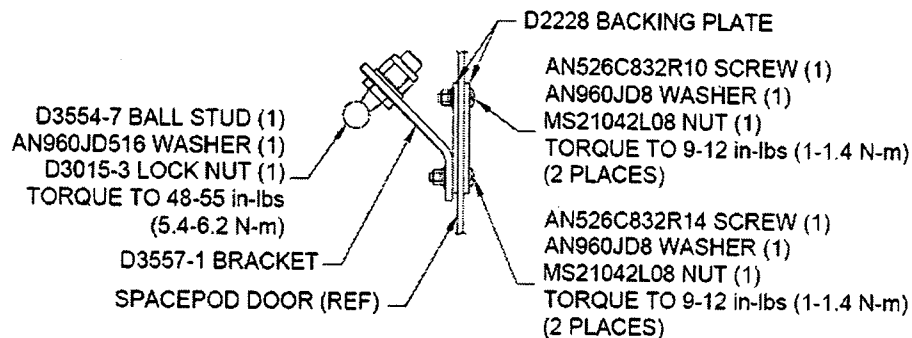


FIGURE 16 – BRACKET AND BALL STUD INSTALLATION ON SPACEPOD™ DOOR
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



SECTION 'K-K'

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- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the *Spacepod™* body.
 - Remove the door and drill $\varnothing 0.375$ " holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the *Spacepod™* door and hinges and transfer drill the $\varnothing 0.172$ " D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and *Spacepod™* door as shown in Figure 17(b).

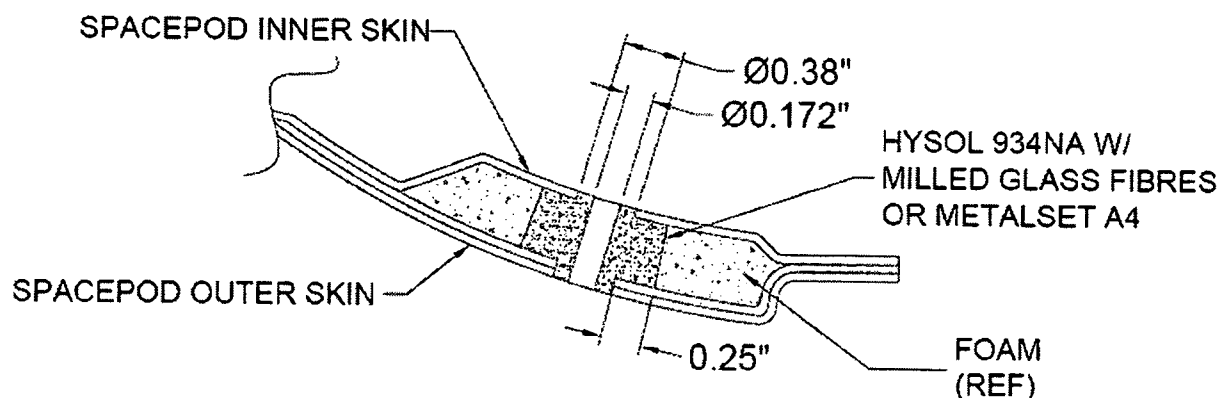
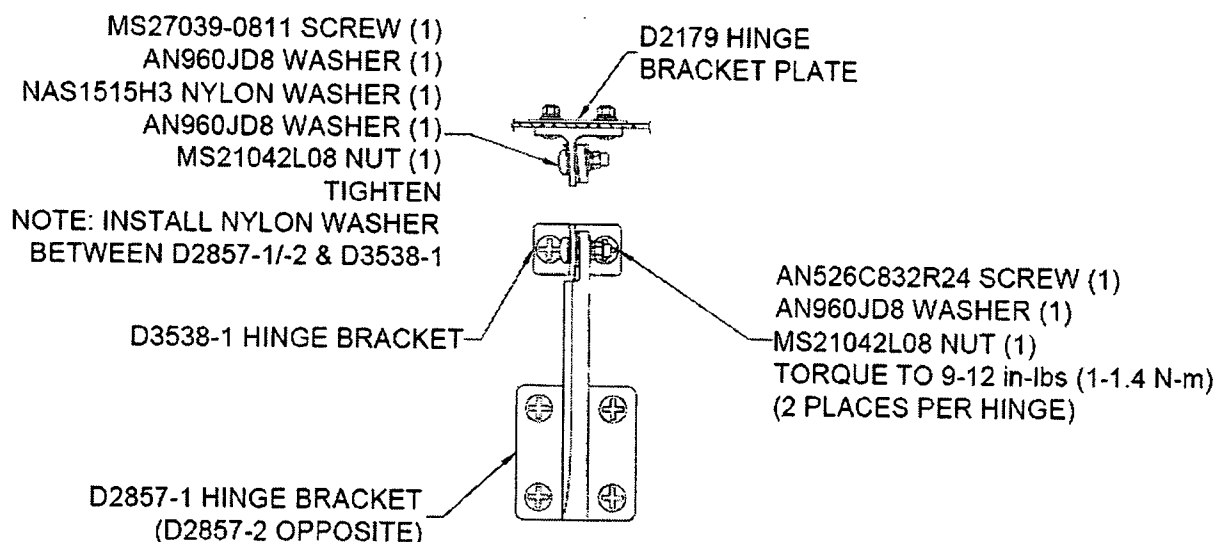


FIGURE 17(a) – COMPOSITE MODIFICATION



**FIGURE 17(b) – HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 OPPOSITE)**

Alex Pharand

From: Linda Lacelle
Sent: January-26-15 1:58 PM
To: Alex Pharand
Subject: FW: Epocast 50A vs A1

From: Laura Hluchaniuk [mailto:toronto@ebpltd.com]
Sent: January-26-15 1:57 PM
To: Linda Lacelle
Subject: RE: Epocast 50A vs A1

50A is no longer available, there was a reformulation of the product which they renamed 50A1

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: Monday, January 26, 2015 1:28 PM
To: toronto@ebpltd.com
Subject: Epocast 50A vs A1
Importance: High

Good Afternoon,
Could you please tell us what the difference is between the Epocast 50A and Epocast 50A1 ?

Thank you

Linda Lacelle
Production manager

DART AEROSPACE
T 1-613-632-5200 Ext: 235

